

206-1028.023

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:08:37 PM
 User: Kim Johnston

Process Sheet

step 28/06

Split 706.2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32253A-1.2
 Estimate Number : 11664
 P.O. Number : N/A
 This Issue : 5/10/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 31241A
 Written By :
 Checked & Approved By : 07.05.10
 Comment : Est Rev: D As Per Ecn 766 06-01-06 JLM

Drawing Name : FLOAT STEP ASSEMBLY LH (206/407)

Part Number : D2842041
 Drawing Number : D2842 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 5/30/2007

Qty: 4 Um: Each

970

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion B31984

Check Material for any Dents or Defects

0.7 02.06.19

4

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 Q.M 07.06.19
 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
 3-Deburr and bevel ends for welding

4

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 206 Step Endplate
 Pick:
 Qty Part Number Description Batch
 2 D2734 End Cap B30883

07.06.19 4

4.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Pick:
 Qty Part Number Description Batch

07.06.19 4

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 D3459-3 Lug

331238

SE 06.06.19

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3459-1 Lug

330909

SE 01.06.19

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT as per Dwg D2842

A/R

AL Rod

Batch:

M102756
M104305

2-Grind end cap weld flush

SE 07.06.20

FF 07.06.20

PE 07.06.20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.7

02.16.20

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

to: Thursday, 5/10/2007 2:08:38 PM
from: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

2-Grind end cap weld flush.

9.m

07.06.21

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.6.5.1) as per QSI 005 4.3

07-06-25

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3 NAS1329C3KB130

Insert

M102974

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

M19527

07-06-25

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Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3L

WASHER

M104603

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

M102473

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M104733

07-06-25 (3)

20.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

07/2/03 (2)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPN B32253

07/2/03 (2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

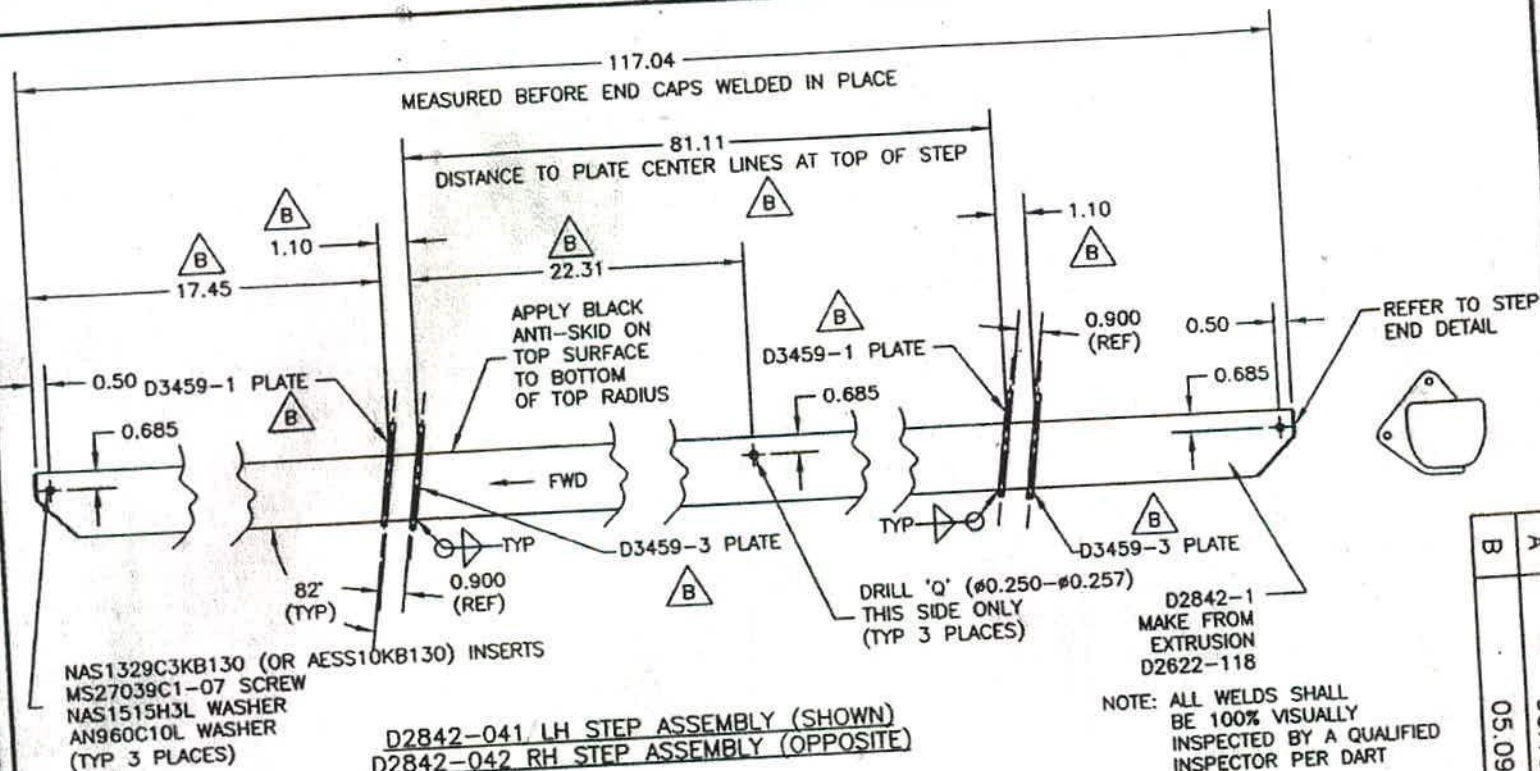
07/2/04

Job Completion



07-07-04

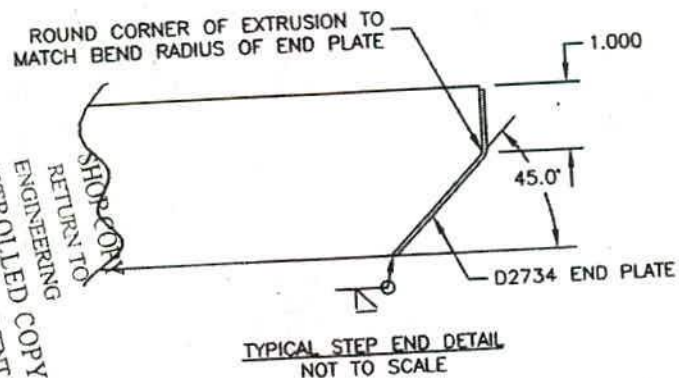
DART



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AES510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C 10L	WASHER

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D2842-041/-042 FLOAT STEP ASSEMBLY

- D2842-0417-042 1.831 2.7
- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
8-11-14

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